

Split

Work Order ID 87938-2

87938

Page 1

July-19-12 11:30:14 AM

Item ID: D3245-043

Accept

N9000040100

Setup Start *NS1*

Revision ID:

Stop *NS2*

Item Name: Door Assembly

Start Date: 19/07/2012 Start Qty: 10.00

10

Cust Item ID:

Required Date: 02/08/2012 Req'd Qty: 10.00

10

Customer:

Reference:

Run Start *NR1*

Approvals: Process Plan: *MLJ*

Date: 12/07/19 Tooling:

Date:

Stop *NR2*

QC:

Date: SPC (Y/N):

Date:

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

Draw Nbr	Revision Nbr
D3245	C

100 Pick Kit 0.00

100

Packaging Memo 0.00

Packaging

110 Small Fab 0.00

110

Small Fab Memo 0.00

Small Fab 1-Install Studs and Gromets as per Dwg D32453-Bond Gasket using 3M ADHESIVE as per Dwg D3245A/R 3M 1300/1300L ADHESIVE
Batch: *1124297*

120 QC5- Inspect part completeness to step on W/O 0.00

120

QC Memo 0.00

Quality Control



13321

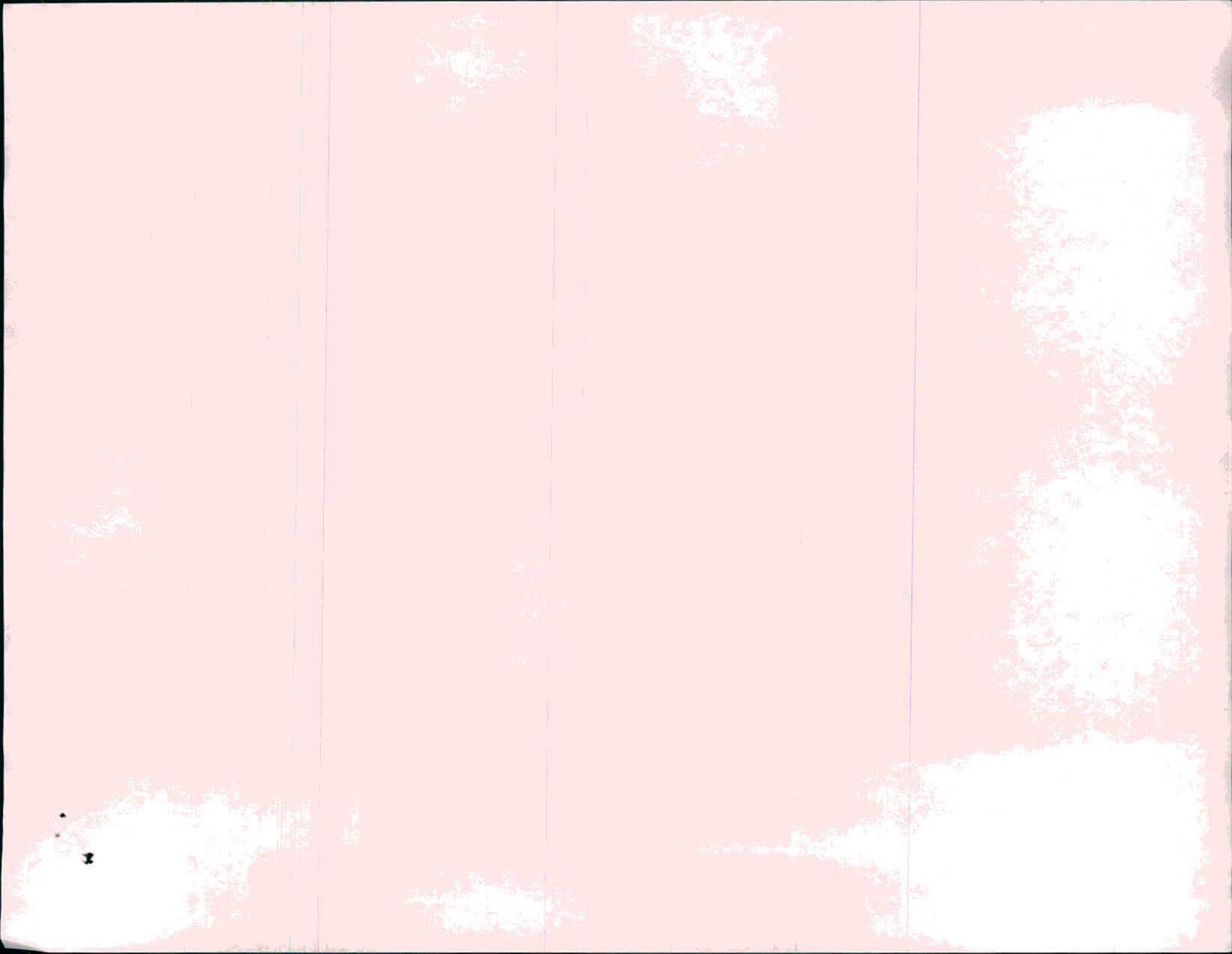
9x

12/03/20

9x

12/03/21

9



Work Order ID 87938

July-19-12 11:30:14 AM

87938

Page 2

Item ID: D3245-043 Accept ***N900040100*** Setup Start ***NS1***
 Revision ID: Stop ***NS2***
 Item Name: Door Assembly
 Start Date: 19/07/2012 Start Qty: 10.00 ***10*** Cust Item ID:
 Required Date: 02/08/2012 Req'd Qty: 10.00 ***10*** Customer:
 Reference:

Approvals: Process Plan: Date: Tooling: Date: Run Start ***NR1***
 QC: Date: SPC (Y/N): Date: Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130	Identify as per dwg & Stock Location:	0.00							
130									
Packaging	Memo	0.00							
Packaging									
140	QC21- Final Inspection - Work Order Release	0.00							
140									
QC	Memo	0.00							
Quality Control									

13/4/12

13/4/10

mf
13-4-9

Picklist Print

July 19-12 11:30:17 AM

Page 1

Work Order ID: 87938

Parent Item: D3245-043

Parent Item Name: Door Assembly

87938

D3245-043

Start Date: 19/07/2012

Start Qty: 10.00

Required Date: 02/08/2012

Required Qty: 10.00

Comments: IPP Rev :A New Issue 07-09-11 JLM Verified By:EC
IPP Rev:b ECN 1052 07-10-31 DD verified by:

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	-------------	--------------	---------------	----------------	--------

2351-20-012-C3Y Purchased No

2351-20-012-C3Y

STUD

Location

Loc Qty

Loc Code

ST400

107

122149

107

100

Each

164.0000

8

80

127H-35

Purchased

No

127H-35

HALF GROMMET

Location

Loc Qty

Loc Code

GA

16

119545

16

ST378

140

121827

140

ST398

8

117203

5

118261

3

D3245-3

Manufactured

No

D3245-3

Door

Location

Loc Qty

Loc Code

GA

25

77821

5

85956

10

86106

10

72
80
33
80
80
72
10
10
79

13/03/21
1122819 (39)
13/03/21
1122800
13/03/20

Picklist Print

July-19-12 11:30:17 AM

Page 2

Work Order ID: 87938

87938

Parent Item: D3245-043

D3245-043

Parent Item Name: Door Assembly

Start Date: 19/07/2012

Required Date: 02/08/2012

Start Qty: 10.00

Required Qty: 10.00

~~D3245-7~~
~~*D3245-7*~~
Gasket

Manufactured No

110 Each

34.0000

1

10

**

EP 13/03/20

Location

Loc Qty

Loc Code

GA

14

83197

2

85957

12

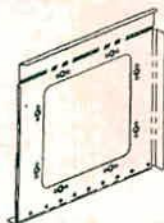
ST232A

20

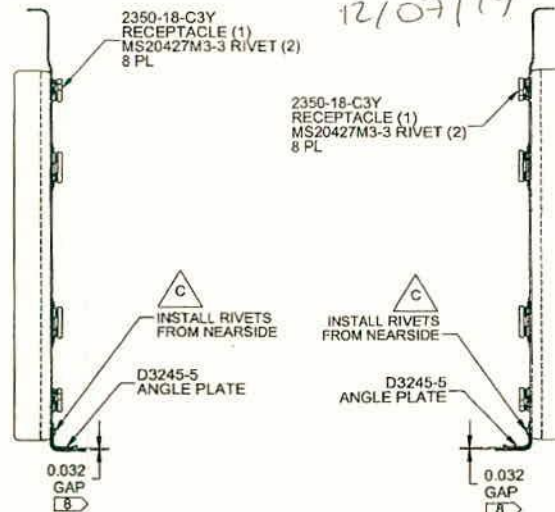
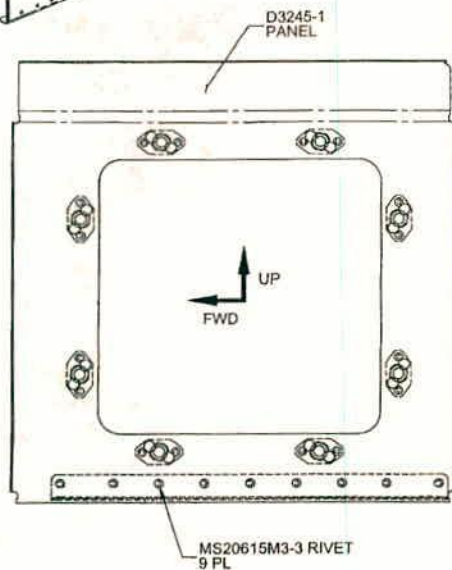
86107

20

4
5

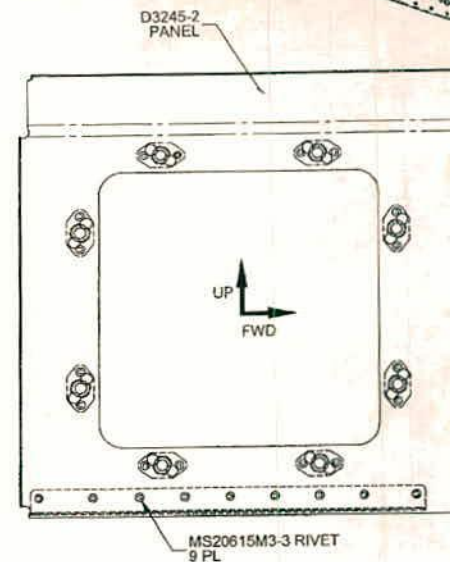
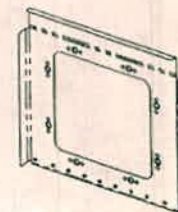


D3245-041 ACCESS PANEL ASSY (LH)



STUDY
RETURNED
(ENGINEER)
UNCONTROLLED COPY
SUBMIT TO APPROVAL
WITHOUT NOTICE
WORK ORDER
NO. 8793845
12/07/19

D3245-042 ACCESS PANEL ASSY (RH)



RELEASED
2012-05-07

QTY -041	QTY -042	P/N	DESCRIPTION
X	X	D3245-041	ACCESS PANEL ASSY (LH)
		D3245-042	ACCESS PANEL ASSY (RH)
1		D3245-1	PANEL
1	1	D3245-2	PANEL
8	8	D3245-5	ANGLE PLATE
16	16	2350-18-C3Y	RECEPTACLE
9	9	MS20427M3-3	RIVET
		MS20615M3-3	RIVET

NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) ASSEMBLE IN ACCORDANCE WITH DART QSI 002
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3245-XX" AND B/N "BXXXXX" PER QSI 044 METHOD 6.1
- 7) WEIGHT: 0.83 lbs
- 8) TEMPORARILY INSERT A 0.032" GAUGE PLATE PRIOR TO RIVETING D3245-5 TO PANEL

C	ADDED NOTE & SHEET 1: SPECIFIED RIVET ORIENTATION (B4-1, B5-1) CHANGED 1/4-TURN STUD FROM 2351-20-009-C3Y TO 2351-20-012-C3Y (D5-2) HOLE SIZE WAS 0.098, 9 PLACES (D6-5) HOLE SIZE WAS 0.219, 6 PLACES (D7-5) REF: PAR 12-165	RP	12.04.11
B	REMOVE Ø 0.204 HOLES FROM D3245-1/1P, REMOVE MS21090-L3K NUTPLATES & DURABLE BLACK GASKETS FROM D3245-041/042. HOLES AND ITEMS ARE NOW PART OF INSTALLATION. ASSIGN P/Ns TO GASKETS & REFORMAT DRAWING	MB	07.10.02
A	NEW ISSUE	RF	04.01.27
REV.	DESCRIPTION	BY	DATE
DESIGN	RF		
DRAWN	MB		
CHECKED	A.P.		
MFG. APPR.			
APPROVED			
DE APPR.			
DATE	12.04.11		

DART AEROSPACE LTD
HAWKESBURY, ONTARIO, CANADA

DRAWING NO. D3245
TITLE ACCESS PANEL ASSY
REV. C
SHEET 1 OF 7
SCALE NTS

COPYRIGHT © 2004 BY DART AEROSPACE LTD
THIS DOCUMENT IS PROVIDED AS INFORMATION AND IS NOT TO BE USED FOR ANY PURPOSES WITHOUT THE EXPRESS PERMISSION OF DART AEROSPACE LTD

87938

D3245-3 DOOR

2351-20-012-C3Y STUD
127H-35 GROMMET
8 PL

8.00
REF

8.00 REF

D3245-7 GASKET
REF

INSTALL D3245-7
GASKET ON THIS SIDE

D3245-043 DOOR ASSY

QTY -043	P/N	DESCRIPTION
X	D3245-043	ACCESS PANEL ASSY
1	D3245-3	DOOR
1	D3245-7	GASKET
8	127H-35	GROMMET
8	2351-20-012-C3Y	STUD

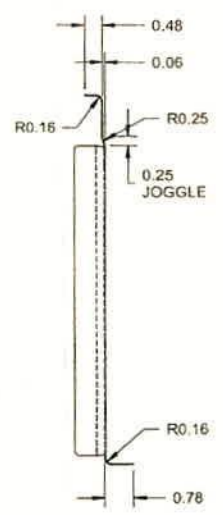
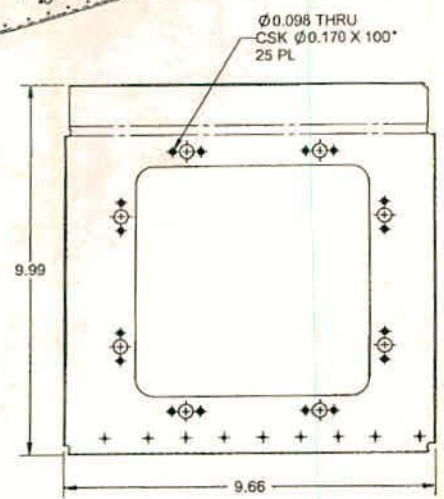
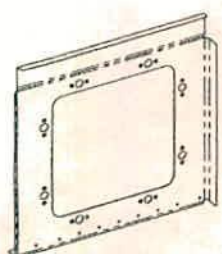
NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: N/A
- 6) INSTALL D3245-7 GASKET USING 3M SCOTCH-GRIP 1300/1300L ADHESIVE IN ACCORDANCE WITH MANUFACTURER'S INSTRUCTIONS
- 7) ASSEMBLE IN ACCORDANCE WITH DART QSI 002
- 8) IDENTIFICATION: IDENTIFY WITH DART P/N "D3245-043" AND B/N "BXXXXX" PER QSI 044 METHOD 6.1
- 9) WEIGHT: 0.72 lbs

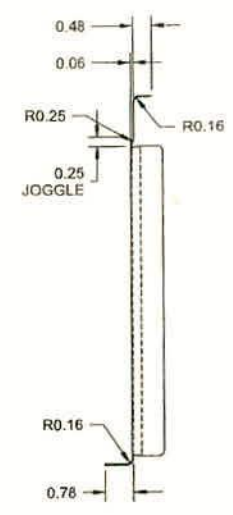
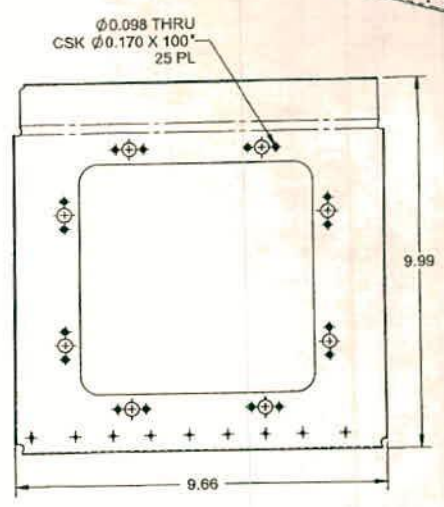
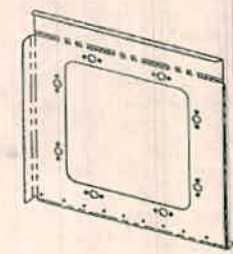
DESIGN	RF	DART AEROSPACE LTD	
DRAWN	MB	HAWKESBURY, ONTARIO, CANADA	
CHECKED	AL	DRAWING NO.	REV. C
MFG. APPR.		D3245	SHEET 2 OF 7
APPROVED		TITLE	SCALE
DE APPR.		ACCESS PANEL ASSY	NTS
DATE	12.04.11	COPYRIGHT © 2004 BY DART AEROSPACE LTD THIS DOCUMENT IS UNCLASSIFIED AND IS NOT TO BE RELEASED FOR ANY PURPOSE OR (OWN) OR (UNCLASSIFIED) TO ANY OTHER PERSON OR ENTITY WITHOUT THE EXPRESS WRITTEN PERMISSION OF DART AEROSPACE LTD.	

LEASED
2012-05-07

87958



D3245-1 PANEL (LH)



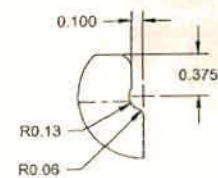
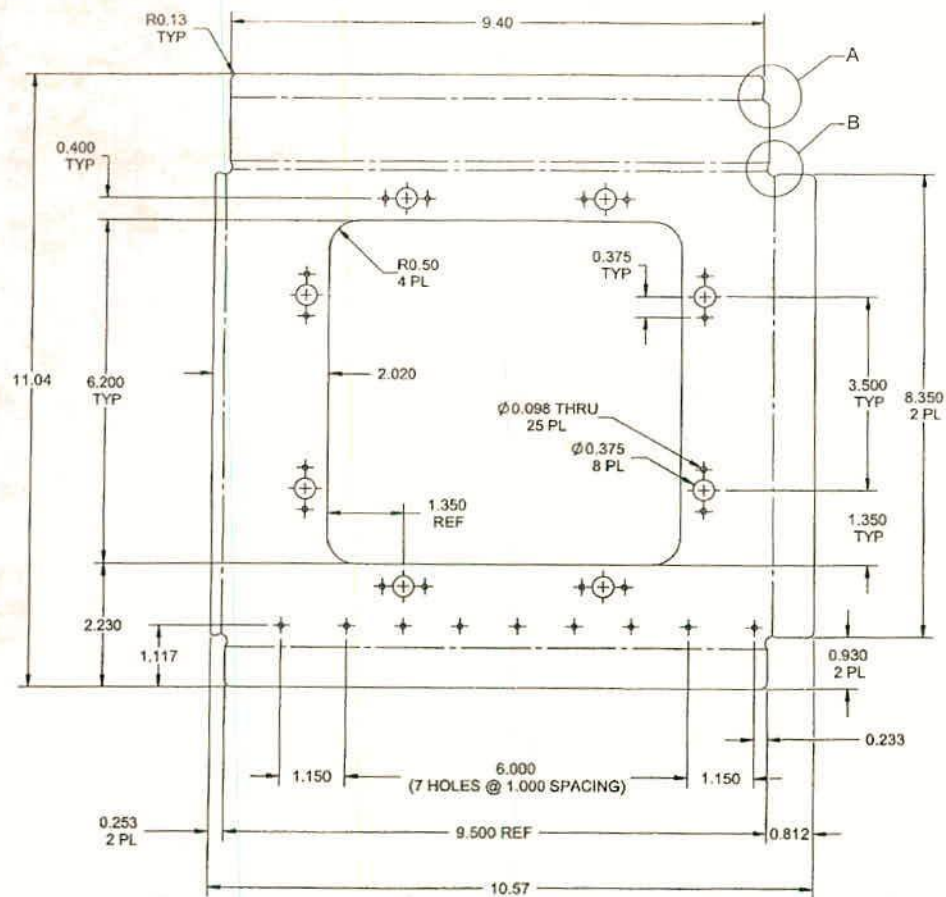
D3245-2 PANEL (RH)

- NOTES:**
- 1) MATERIAL: MAKE FROM D3245-1F
 - 2) FINISH: NONE
 - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK SHARP EDGES: N/A
 - 6) IDENTIFICATION: N/A
 - 7) WEIGHT: 0.70 lbs

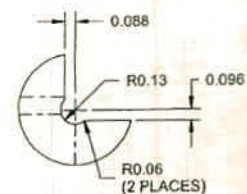
RELEASED
2012-05-07

DESIGN	RF	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	MB		
CHECKED	AP	DRAWING NO. D3245	REV. C
MFG. APPR.			SHEET 3 OF 7
APPROVED		TITLE ACCESS PANEL ASSY	SCALE NTS
DE APPR.		COPYRIGHT © 2004 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL, AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT NOT BE REPRODUCED FOR ANY PURPOSE OR LOANED OR CONSIDERED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	
DATE	12.04.11		

87938



DETAIL A: RELIEF
SCALE 1:1



DETAIL B: RELIEF
TYP. 4 PL
SCALE 1:1

DELETED
2012-05-07
JWP

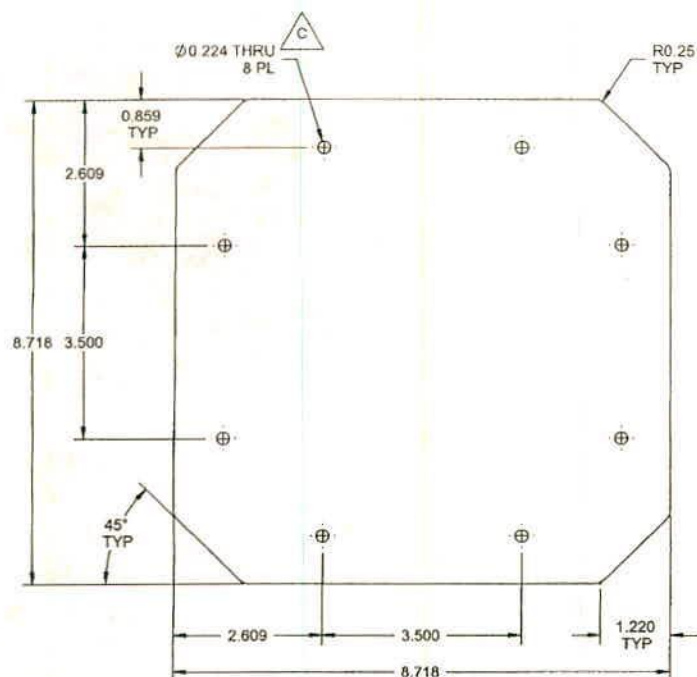
NOTES:

- 1) MATERIAL: AISI 304/316 SS SHEET, 0.032 THICK, ANNEALED, 2B FINISH, PER MIL-S-5059 OR AMS 5513 (304) OR AMS 5524 (316) OR ASTM A240 OR ASME SA240 (REF. DART SPEC. M304S22GA)
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 0.70 lbs

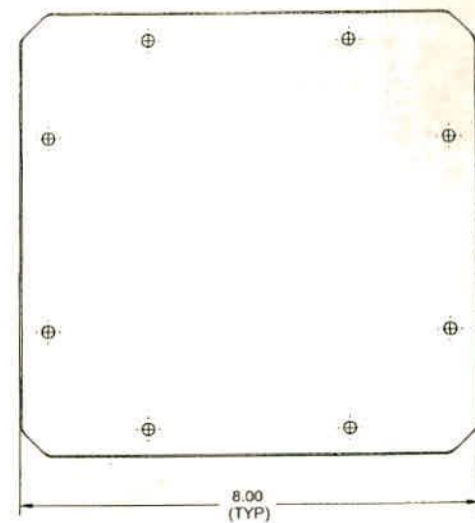
D3245-1F PANEL FLAT PATTERN

DESIGN	RF	DART AEROSPACE LTD	
DRAWN	MB	HAWKESBURY, ONTARIO, CANADA	
CHECKED	A.P.	DRAWING NO.	REV. C
MFG. APPR.	JWP	D3245	SHEET 4 OF 7
APPROVED	JWP	TITLE	SCALE
DE APPR.	JWP	ACCESS PANEL ASSY	NTS
DATE	12.04.11	COPYRIGHT © 2004 BY DART AEROSPACE LTD THIS DOCUMENT IS PROPRIETARY AND CONFIDENTIAL. NO PART OF THIS DOCUMENT IS TO BE REPRODUCED OR TRANSMITTED IN ANY FORM OR BY ANY MEANS WITHOUT THE WRITTEN PERMISSION OF DART AEROSPACE LTD.	

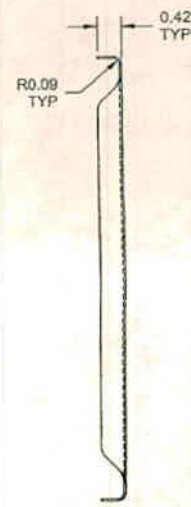
87938



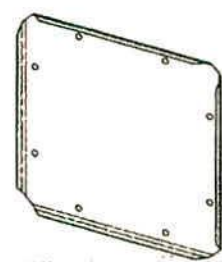
D3245-3F DOOR FLAT PATTERN



D3245-3 DOOR
(MADE FROM D3245-3F)



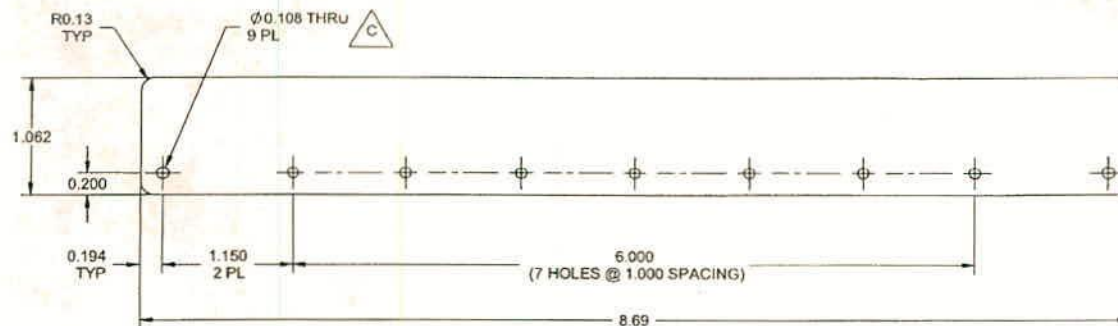
- NOTES:**
- 1) MATERIAL: AISI 304/316 SS SHEET, 0.032 THICK, ANNEALED, 2B FINISH, PER MIL-S-5059 OR AMS 5513 (304) OR AMS 5524 (316) OR ASTM A240 OR ASME SA240 (REF. DART SPEC. M304S22GA)
 - 2) FINISH: NONE
 - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
 - 6) IDENTIFICATION: N/A
 - 7) WEIGHT: 0.66 lbs



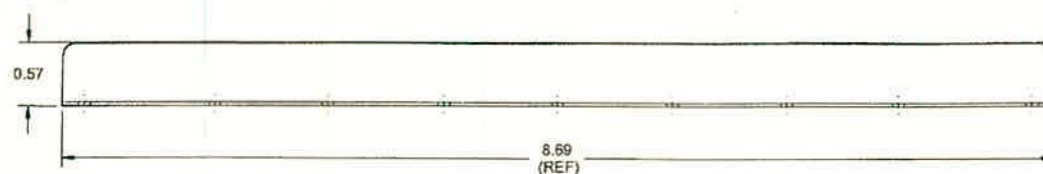
RELEASED
2012-05-07

DESIGN	RF	DART AEROSPACE LTD	
DRAWN	MB	HAWKESBURY, ONTARIO, CANADA	
CHECKED	AP	DRAWING NO. D3245	REV. C
MFG. APPR.		TITLE	SCALE
APPROVED		ACCESS PANEL ASSY	NTS
DE APPR.		COPYRIGHT © 2004 BY DART AEROSPACE LTD	
DATE	12.04.11	THIS DOCUMENT IS UNCLASSIFIED AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSES OR COPIED OR REPRODUCED IN ANY MANNER WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	

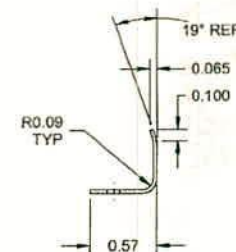
83938



D3245-5F FLAT PATTERN



D3245-5 ANGLE PLATE
(MAKE FROM D3245-5F)



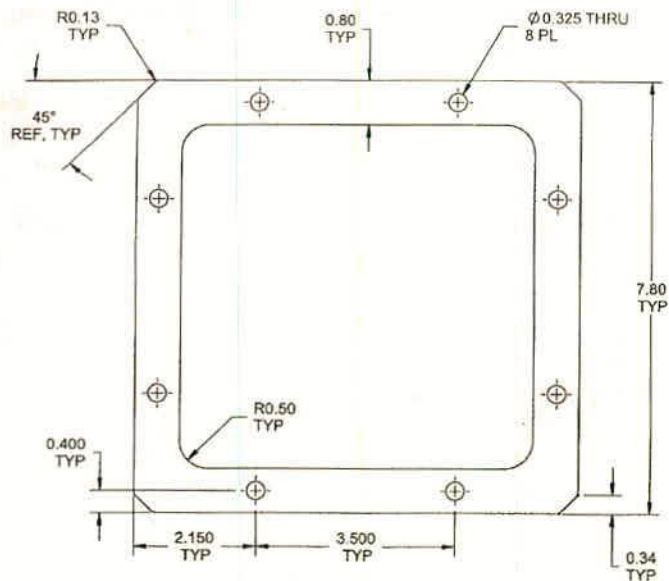
REL. 1.02
R 2012-07-07

NOTES:

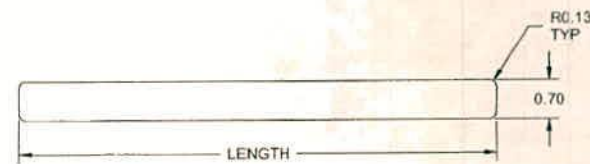
- 1) MATERIAL: AISI 304/316 SS SHEET, 0.032 THICK, ANNEALED, 2B FINISH, PER MIL-S-5059 OR AMS 5513 (304) OR AMS 5524 (316) OR ASTM A240 OR ASME SA240 (REF. DART SPEC. M304S22GA)
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 0.08 lbs

DESIGN	RF	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	MB		
CHECKED	A.V.	DRAWING NO.	REV. C
MFG. APPR.	ED	D3245	SHEET 6 OF 7
APPROVED	AW	TITLE	SCALE
DE APPR.		ACCESS PANEL ASSY	NTS
DATE	12.04.11	COPYRIGHT © 2014 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL. USE IS LIMITED TO THE SUPPLIER'S OBLIGATION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR REPRODUCED IN ANY FORM OR BY ANY MEANS WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	

87950



D3245-7 GASKET



D3245-X GASKET

P/N	LENGTH
D3245-9	8.35
D3245-11	9.01
D3245-13	9.50

NOTES:

- 1) MATERIAL: DURABLE BLACK GASKET, 0.035 THICK
PER MIL-A-7021C OR MIL-A-17472B OR MIL-G-12803A OR AMS 3232
(REF. DART SPEC. MDURAS.035)
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: N/A
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: LESS THAN 0.01lbs

2012-05-07

DESIGN	RF	DART AEROSPACE LTD	
DRAWN	MB	HAWKESBURY, ONTARIO, CANADA	
CHECKED	AJ	DRAWING NO.	REV. C
MFG. APPR.	ES	D3245	SHEET 7 OF 7
APPROVED	TH	TITLE	SCALE
DE APPR.	TH	ACCESS PANEL ASSY	NTS
DATE	12.04.11	COPYRIGHT © 2004 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS UNDERSTANDING THAT IT IS NOT TO BE USED FOR ANY PURPOSES OR COPIED OR REPRODUCED IN ANY MANNER WITHOUT THE WRITTEN PERMISSION OF DART AEROSPACE LTD.	